



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAP

D5575-3
Job Sheet 184528



Part No: D5575-3

Job Qty: 10 ea

Part Name: Break Away Tip, Lower Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: Dwg D5575-3 Rev B IPP Rev A New issue 18/02/15 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-1		DIP 18-10-31
110	CNC Vertical Machining	10 pcs	11/2/18	11/2/18	0.00	5.00	HAAS1-1		DIP 18-10-31
120	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-1		DIP 18-10-31 VHS
130	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-1		21/18/11/01
135	Outsource	10 pcs	11/2/18	11/2/18			ATG001-VC	10	GT 18-11-1
140	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging2		NOV 05 2018 AS
150	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC6		NOV 07 2018 68
180	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		NOV 07 2018 9-89
190	QC21-SA	10 Ea	11/2/18	11/2/18	0.00	0.00	QC21		NOV 08 2018

Part Op 90 - Cut Blanks at 9.250"

Descriptions: 110 - 1-Machine per folio FB770 DWG REV: B FOLIO REV: AA 2- deburr and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

135 - Issue P/O to ATG: 20041546 Black Anodize & Prime as per Dwg. D5575-3 Certification of Conformity is required.

140 - Certification of Conformity is required.

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X0.750	7075-T6S Sheet 2" Thick Plate X 0.75" Wide	7.7100 ft (.771 ea)	90-Start up Operation	5066611 x3 5044634 x7

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S2.000X0.750	8	15	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																						
Large Fab ☐	Composite ☐	Supplier ☐																																																																							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																																																																			
Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632 - 6200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S123316 Part: D5575 - 3 Job No: 184528 Serial No/Batch: S123316 Revision: B Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/31/18				Disposition 				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																	
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER : ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER : ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																																																							
Design ☐	Operator ☐	Bending ☐																																																																							
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐																																																																							
Equip/Tooling ☐	Supplier ☐	Cracks ☐																																																																							
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐																																																																							
Material ☐	Use for Testing ☐	Cuffs ☐																																																																							
Internal Transport ☐	Poor Information ☐	Crushing ☐																																																																							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																																							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																																							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																																							
Past Expiry Date ☐	Manufacturing Process ☐																																																																								
Misidentified ☐	Past Due ☐	OTHER : ☐																																																																							
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																							
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																							
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																							
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																							
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																							
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																							
Countersink ☐	Off-set ☐	Drawing ☐																																																																							
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																							
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																							
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																							

DART AEROSPACE LTD		Work Order:	184528
Description:		Part Number:	D5575-3
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.113 x 45°	±.010 / ±.5°	0.112 x 45°	✓		Vern	
0.130 x 45°	±.010 / ±.5°	0.130 x 45°	✓		"	
0.385	±.010	0.384	✓		"	
0.095	±.010	0.098	✓		HG	
4.57	±.030	4.567	✓		"	
0.930	±.010	0.927	✓		Vern.	
0.750	±.010	0.752	✓		"	
0.113	±.010	0.105	✓		"	
0.348	+0.003 / -0.000	0.350	✓		G.P.	
0.574	REF	0.573	✓		Vern.	
0.113	±.010	0.114	✓		"	
R0.12	±.030	0.125	✓		R.G.	
7.99	±.030	7.985	✓		H.G.	
5.25	±.030	5.251	✓		"	
Ø0.129	+0.005 / -0.001	0.129	✓		G.P.	
3.31	±.030	3.310	✓		Vern.	
0.682	±.010	0.683	✓		"	
1.500	±.010	1.500	✓		"	
0.375	±.010	0.375	✓		"	
2.60	±.030	2.601	✓		H.G.	

Measured by: DJP	Checked by: [Signature]	QC Inspector:
Date: 18-10-31	Date: 18/10/01	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041546**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041546

PO Date: 11/1/18

Due Date: 11/5/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Attention: Lalande, Marc-Andre

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: **rush PO :(**

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185154	646.9714	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	11/5/18	4 pcs	0 pcs	4 pcs	\$17.90/pcs	\$71.60

4 X NOV 05 2018

Line Item Note *advise of fastest ETA *

2	184528	D5575-3	Break Away Tip, Lower Deflector : Various STC's Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5575-3 Certification of Conformity is required.	Firmed	-	11/5/18	10 pcs	0 pcs	10 pcs	\$11.90/pcs	\$119.00
---	--------	---------	--	--------	---	---------	--------	-------	--------	-------------	----------

10 X NOV 05 2018

DAS
68
9-89

Line Item Note **rush for Monday**

Plex 11/5/18 3:04 PM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041546**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	184527	D5575-1	Deflector, Lower Cable Cutter : Various STC's Issue P/O to ATG : Black Anodize & Prime as per Dwg. D5575-1 Certification of Conformity is required.	Firmed	-	11/5/18	10 pcs	0 pcs	10 pcs	\$11.90/pcs	\$119.00
Line Item Note **rush for Monday** 10 x NOV 05 2018											
4	184742	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	11/5/18	20 pcs	0 pcs	20 pcs	\$10.00/pcs	\$200.00
Line Item Note ** Can I have this by Monday or Tuesday morning at latest? **											
										Grand Total:	\$509.60

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 3:04 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T1
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916433

Date: 05-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 646.9714 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24002	Rev:	PO: PO041546 Line: 1
10 ea	Part: D5575-3 Break Away Tip Lower Deflector Hard Black Anodize per MIL-A-8625F, Type II, Class 2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Job: 24003	Rev: B	PO: PO041546 Line: 2
10 ea	Part: D5575-1 Deflector, Lower Cable Cutter Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24004	Rev: A	PO: PO041546 Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>5/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

DAS
68
9-89

